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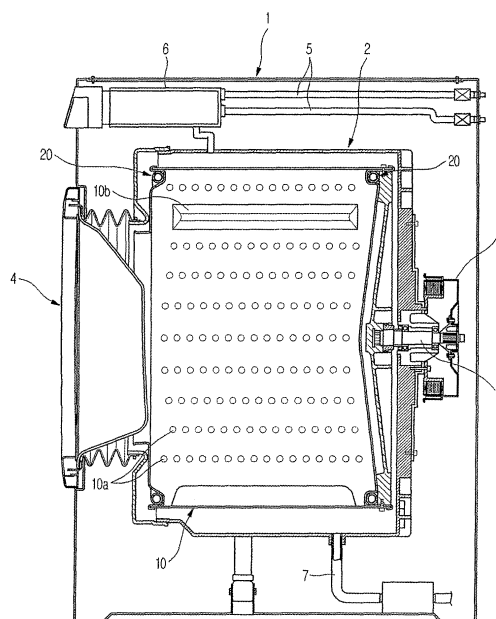
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(54) **Washing machine having balancer and method of manufacturing balancer thereof**

(57) A washing machine is provided having at least one balancer (20) and a method of manufacturing a balancer (20) thereof is further provided, the method and machine capable of reducing a manufacturing cost and an assembly time, and allowing the balancer (20) assembled to a spin tub (10) to be easily replaced with a new balancer. The balancer (20) applied to the washing machine and the method of manufacturing the balancer (20) of the washing machine are adapted such that a pipe is formed in an annular shape and is assembled to a spin tub (10), so that a manufacturing cost and an assembly time can be reduced to improve mass productivity. Further, when the balancer (20) is determined to fail after being assembled to the spin tub (10), the balancer (20) can be rapidly and conveniently replaced with a new balancer, so that material costs can be reduced.

FIG.1





European Patent  
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# EUROPEAN SEARCH REPORT

Application Number  
EP 07 10 9106

DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (IPC)
X	SU 1 461 796 A1 (RIZHSKIJ POLT INST [SU]) 28 February 1989 (1989-02-28) * abstract; figure 1 *	1-17	INV. D06F37/04 D06F37/22
X	US 5 870 908 A (RUSHLOW PAUL S [US]) 16 February 1999 (1999-02-16) * claim 1; figure 1 *	1-17	
X	US 3 321 997 A (PETERSON ROBERT C) 30 May 1967 (1967-05-30) * claim 3; figure 1 *	1-17	
			TECHNICAL FIELDS SEARCHED (IPC)
			D06F F16F
The present search report has been drawn up for all claims			
Place of search		Date of completion of the search	Examiner
Munich		21 July 2008	Dupuis, Jean-Luc
<p>CATEGORY OF CITED DOCUMENTS</p> <p>X : particularly relevant if taken alone  Y : particularly relevant if combined with another document of the same category  A : technological background  O : non-written disclosure  P : intermediate document</p> <p>T : theory or principle underlying the invention  E : earlier patent document, but published on, or after the filing date  D : document cited in the application  L : document cited for other reasons  &amp; : member of the same patent family, corresponding document</p>			

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**ANNEX TO THE EUROPEAN SEARCH REPORT  
ON EUROPEAN PATENT APPLICATION NO.**

EP 07 10 9106

This annex lists the patent family members relating to the patent documents cited in the above-mentioned European search report.  
The members are as contained in the European Patent Office EDP file on  
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21-07-2008

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